Shp Jan 15

Work Order ID 89528

89528

August-24-12 10:02:21 AM

Item ID: D4640-15 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Ceiling Protector

Start Date: 8/24/12 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 11/05/12 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4640	~~A~~ B ~~QCN12-652~~ C								
100		0.00							
100						(10)		B13-1-3	
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	Cut as per dwg Prog Rev: C Dwg Rev: C Deburr as required	trumpf							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						(10)		B13-1-3	
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4640-15 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Ceiling Protector

Start Date: 8/24/12 **Start Qty:** 10.00 *10* **Cust Item ID:**
Required Date: 11/05/12 **Req'd Qty:** 10.00 *10* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 15 9-89				10			
120									
QC	**Memo**	0.00							
Quality Control	Use template to mark locations 13.1.4								
130	Identify as per dwg & Stock Location:_____	0.00 APP 89602							
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

13/01/04 SD

13/1/10

13-01-4

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

August-24-12 10:02:20 AM

Work Order ID: 89528

Parent Item: D4640-15 **Start Date:** 8/24/12 **Required Date:** 11/05/12

Parent Item Name: Ceiling Protector **Start Qty:** 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,452.6700	12.6	**132.63158**	140. B13-1-3		

Location	Loc Qty	Loc Code
therm	1452.67	
112176	40.44	
114459	1412.23	123105

(10)

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐				
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐				
Large Fab ☐	Composite ☐	Supplier ☐					

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Bend
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- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	89528
Description: Ceiling Protector	Part Number:	D4640-15
Inspection Dwg: D4640 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	✓		T B01	
22.03	+/-0.030	22.03	✓		T	
20.06	+/-0.030	20.06	✓		T	
13.06	+/-0.030	13.06	✓		T	
3.60	+/-0.030	3.60	✓		T	
8.09	+/-0.030	8.09	✓		T	
20.86	+/-0.030	20.86	✓		T	
3.11	+/-0.030	3.11	✓		T	
7.27	+/-0.030	7.27	✓		T	
5.10	+/-0.030	5.10	✓		T	
4.85	+/-0.030	4.85	✓		T	
13.06	+/-0.030	13.06	✓		T	
1.50	+/-0.030	1.50	✓		T	
5.00	+/-0.030	5.00	✓		T	
57.46	+/-0.030	57.46	✓		T	
82.37	+/-0.030	82.37	✓		T	
Ø8.13	+0.012/-0.001	8.137	✓		✓ B02	
6.77	+/-0.030	6.77	✓		T	
5.72	+/-0.030	5.72	✓		T	
6.13	+/-0.030	6.13	✓		T	
2.21	+/-0.030	2.21	✓		T	
0.88	+/-0.030	.88	✓		T	
7.78	+/-0.030	7.78	✓		T	
7.47	+/-0.030	7.47	✓		T	
Ø0.375	+0.006/-0.001	.380	✓		T	
9.73	+/-0.030	9.73	✓		T	
21.00	+/-0.030	21.00	✓		T	
31.28	+/-0.030	31.28	✓		T	
4.00	+/-0.030	4.00	✓		T	
27.23	+/-0.030	27.23	✓		T	
22.28	+/-0.030	22.28	✓		T	
20.36	+/-0.030	20.36	✓		T	
0.093	+/-0.010	.096	✓ DAS		✓	

Measured by:	RB	Audited by:	15 Dec 89	Preliminary Approval:	
Date:	13-1-3	Date:	13-1-03	Date:	

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

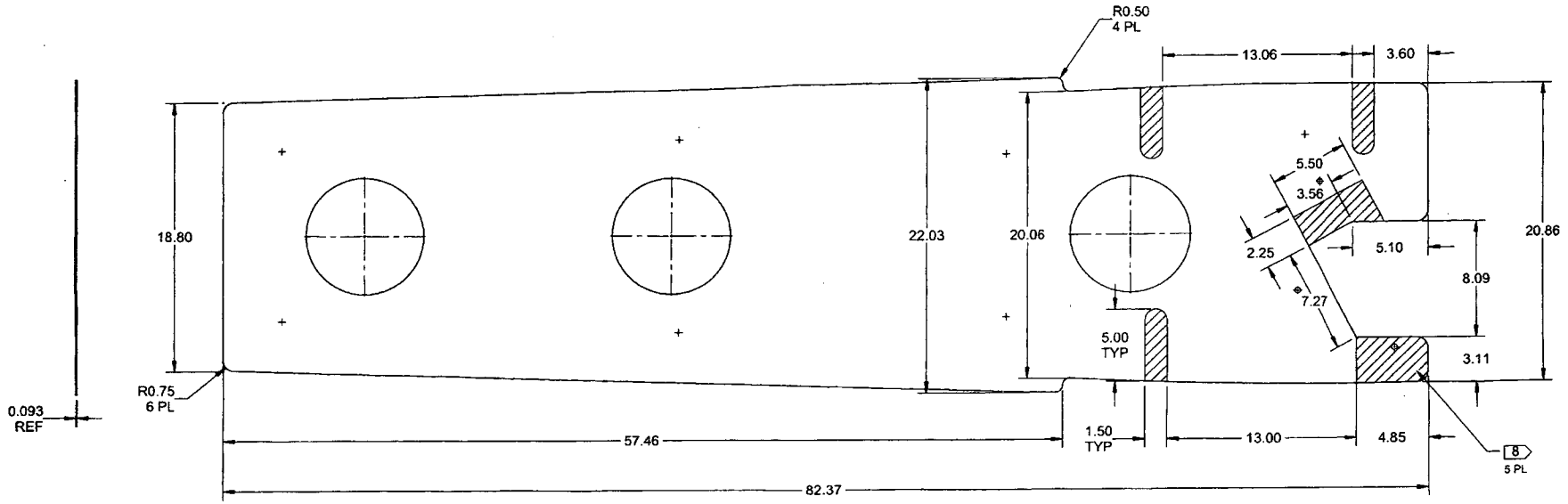
FAULT CATEGORY

Landing Gear

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other



D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

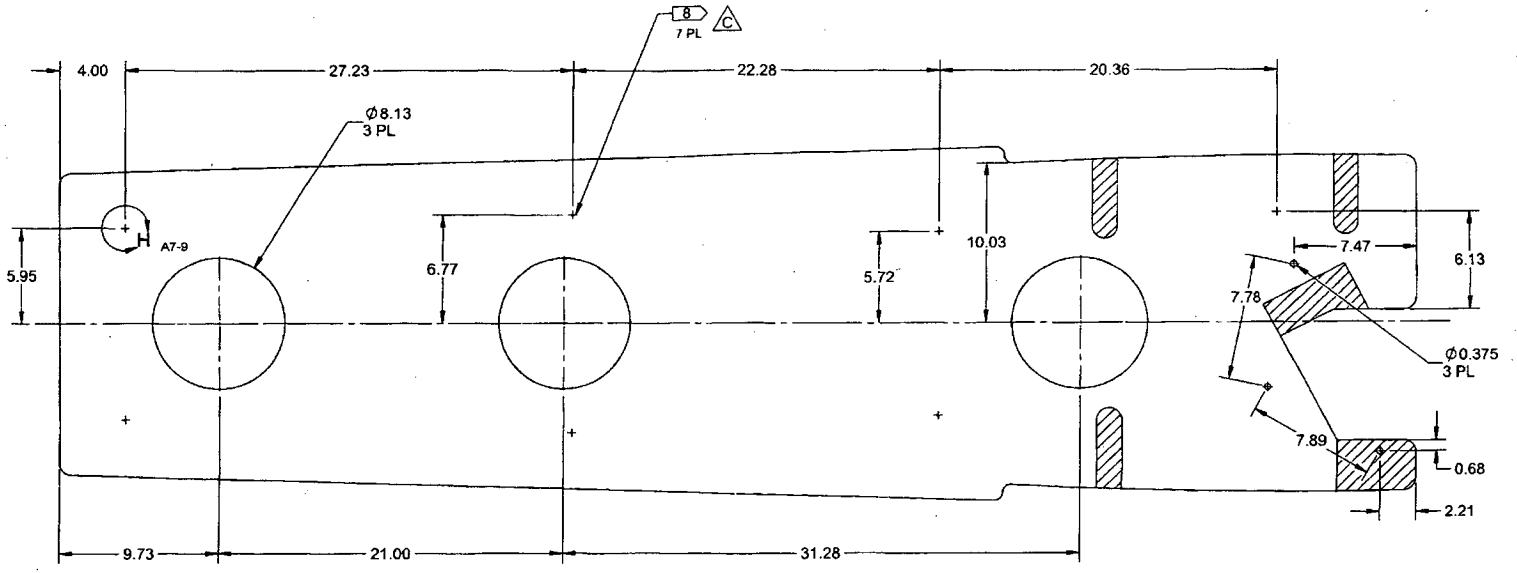
89528

RELEASED
2012 -11- 29

NOTES:
1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
7) WEIGHT: 5.99 lbs (TRIMMED WEIGHT = 5.78 lbs)
8) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREAS
△C

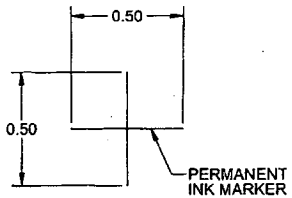
DESIGN	XDF	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4640 REV. C
MFG. APPR.		SHEET 8 OF 9
APPROVED		TITLE BAGGAGE PROTECTOR SCALE NTS
DE APPR.		
DATE	12.11.22	

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D4640-15 CEILING PROTECTOR
SUPPLEMENTAL VIEW

RELEASED
2012 -11- 29



DETAIL H C7-9
NOT TO SCALE
TRIMMED KIT ONLY
C

DESIGN	XDF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4640 REV. C SHEET 9 OF 9
CHECKED		
MFG. APPR.		TITLE BAGGAGE PROTECTOR SCALE NTS
APPROVED		
DE APPR.		
DATE 12.11.22		

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